

Work Order ID 85690

85690

Page 1

June-22-12 1:29:29 PM

Item ID: D412-664-203 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Crosstube Aft
Start Date: 6/13/12 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/14/12 Req'd Qty: 1.00 ***1*** Customer: CU-EAG002
Reference: RMA RA111340 - **RETURN-SCRAP**

Approvals: Process Plan: ✓ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D412-664-243	E/DEO								

100

0.00

100

QC

Quality Control

Memo

INSPECT RA111340

1 X D412-664-203 B42429

NEED CONFIRMATION THAT TUBE WAS NEVER FLOWN....

0.00
-8 12/65/29

SCRAP

110

0.00

110

HandFinish

Hand Finishing

Memo

DISASSEMBLE TUBE

STRIP ENTIRE TUBE

0.00

see attached email
From D.S. tube is
Scrap.

12.06.26

Work Order ID 85690

85690

Page 2

June-22-12 1:29:29 PM

Item ID: D412-664-203

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Aft

Start Date: 6/13/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/14/12 Req'd Qty: 1.00

1

Customer: CU-EAG002

Reference: RMA RA111340

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120									
SprayPaint	Memo	0.00							
Spray Painting	RE-PRIME B _____ REPAINT B _____ PER DRWG D412-664-243, QSI005 ***Mask underside of crosstube as shown*** 1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube with White Imron as per DEO D412-664-243 and QSI 005 4.2 PRIME: Start Time: _____ Finish Time: _____ PAINT: Start Time: _____ Finish Time: _____								
122	QC14- Inspect Spray Paint	0.00							
122									
QC	Memo	0.00							
Quality Control									

SCRAP

Work Order ID 85690

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Page 3

June-22-12 1:29:29 PM

Item ID: D412-664-203

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N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Aft

Start Date: 6/13/12 Start Qty: 1.00

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Cust Item ID:

Required Date: 6/14/12 Req'd Qty: 1.00

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

125

0.00

125

Crosstubes

Crosstubes

Memo

0.00

RE-ASSEMBLE PER DRWG - INDICATE IF TAKING ORIGINAL PARTS OR
NEW PARTS:
2 X MS21920-30
2 X D3595-063-570
4 X MS21920-28
1 X D2896-1
2 X D3189-1

Assemble as per Dwg D412-664-203

1- Install chafing shield as per DEO D412-664-243. Top holes should be facing up.

A/R Proseal 890 Batch: _____
EXP: _____

2- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

3- Install support with Scotch-Weld DP460 and install clamps as per DEO Dwg D412-664-243 using installation jig DT9024. Torque clamps as per dwg
A/R Scotch-Weld DP460 Batch: _____
EXP: _____

SCRAP

Work Order ID 85690***85690***

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June-22-12 1:29:29 PM

Item ID: D412-664-203

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Aft

Start Date: 6/13/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/14/12 Req'd Qty: 1.00

1

Customer: CU-EAG002

Reference: RMA RA111340

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Pick Kit	0.00							
140									
Packaging	Memo	0.00							
Packaging									
150	QC4- 100% Inspect kits for completeness	0.00							
150									
QC	Memo	0.00							
Quality Control									

SCAP

Work Order ID 85690***85690***

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June-22-12 1:29:29 PM

Item ID: D412-664-203

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Aft

Start Date: 6/13/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/14/12 Req'd Qty: 1.00

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Customer: CU-EAG002

Reference: RMA RA111340

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: _____	0.00							
160									
Packaging	Memo	0.00							
Packaging	REPACKAGE PER PPP USING NEW B/N NEW LABELS AND PAPERWORK REQ'D								
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

Scrap

R12-06-26

Picklist Print

June-22-12 1:29:28 PM

Page 1

Work Order ID: 85690

Parent Item: D412-664-203

Parent Item Name: Crosstube Aft

Start Date: 6/13/12

Required Date: 6/14/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:E04.02.16Reformat; Added D3189-1K/DS
 IPP Rev:F 06-03-29 Remove Coments on Pick List JLM
 IPP Rev:G 06.12.08 per ECN 886 EC
 IPP Rev:H 07-04-30 As per Rev D JLM
 IPP Rev:I 08-06-12 add comment in seq. 21 DD verified by:EC IPP rev J 11.04.21 DEO D412-664-243-E-1 EC verified DD IPP REV:K 11.10.03 DEO D412-664-243-E-2 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN6-40A Bolt		Purchased	No				Each	140.0000		4			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST342		140							
				120187		66							
				120833		4							
				121584		20							
				121827		50							
AN6-41A Bolt		Purchased	No				Each	73.0000		2			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST342		73							
				120423		43							
				121825		30							
AN960JD616 Washer	NAS1149D0663J	Purchased	No				Each	0.0000		18			
D2896-1 Support		Manufactured	No				Each	22.0000		1			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				LG052		8							
				80586		8							
				LG053		14							
				74465		14							

Picklist Print

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Page 2

Work Order ID: 85690

Parent Item: D412-664-203

Parent Item Name: Crosstube Aft

Start Date: 6/13/12

Required Date: 6/14/12

Start Qty: 1.00

Required Qty: 1.00

D3189-1
Chafing Shield

Manufactured No

Each 28.0000

2

Location	Loc Qty	Loc Code
FG	4	
36065	4	
LG053	24	
83458	12	
83972	12	

D3595-063-570
RUBBER CUSHION

Manufactured No

Each 153.0000

2

Location	Loc Qty	Loc Code
FG	8	
37971	1	
42243	7	
LG	78	
83294	78	
MAT052	67	
71534	1	
76546	66	

D412-664-203
Crosstube Aft

Manufactured No

Each 3.0000

1

Location	Loc Qty	Loc Code
FG103	1	
83182	1	
Return2012	2	
67058	1	
67434	1	

42429

1

June-22-12 1:29:29 PM

Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 85690

Parent Item: D412-664-203

Parent Item Name: Crosstube Aft

Start Date: 6/13/12

Required Date: 6/14/12

Start Qty: 1.00

Required Qty: 1.00

MS21042L6

Purchased

No

Each 543.0000

6

Nut

Location

Loc Qty

Loc Code

ST300

543

117677

25

118384

3

118927

48

119075

267

120308

200

MS21920-28

Purchased

No

Each 59.0000

4

Clamp(per MIL-DTL-8783C)

Location

Loc Qty

Loc Code

FG

5

105884

5

LG050

46

116839

2

118713

4

120054

2

121067

38

LG051

8

121440

8

MS21920-30

Purchased

No

Each 101.0000

2

clamp(per MIL-DTL-8783C)

Location

Loc Qty

Loc Code

LG

38

119529

38

LG051

63

111258

14

121583

49

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Shop Packet Print

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Item	Qty -243	Part Number	Description
1	X	D412-664-243	CROSSTUBE ASSEMBLY (412 HIGH AFT)
2	1	D30J9-129	CROSSTUBE
3	2	D3595-063-570	RUBBER CUSHION
4	1	D2896-1	SUPPORT
5	2	D3189-1	CHAFING SHIELD
6	2	D2856-600-1009	ABRASION STRIP
7	4	MS21920-28	CLAMP
8	2	MS21920-30	CLAMP (OR MS21920-32)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

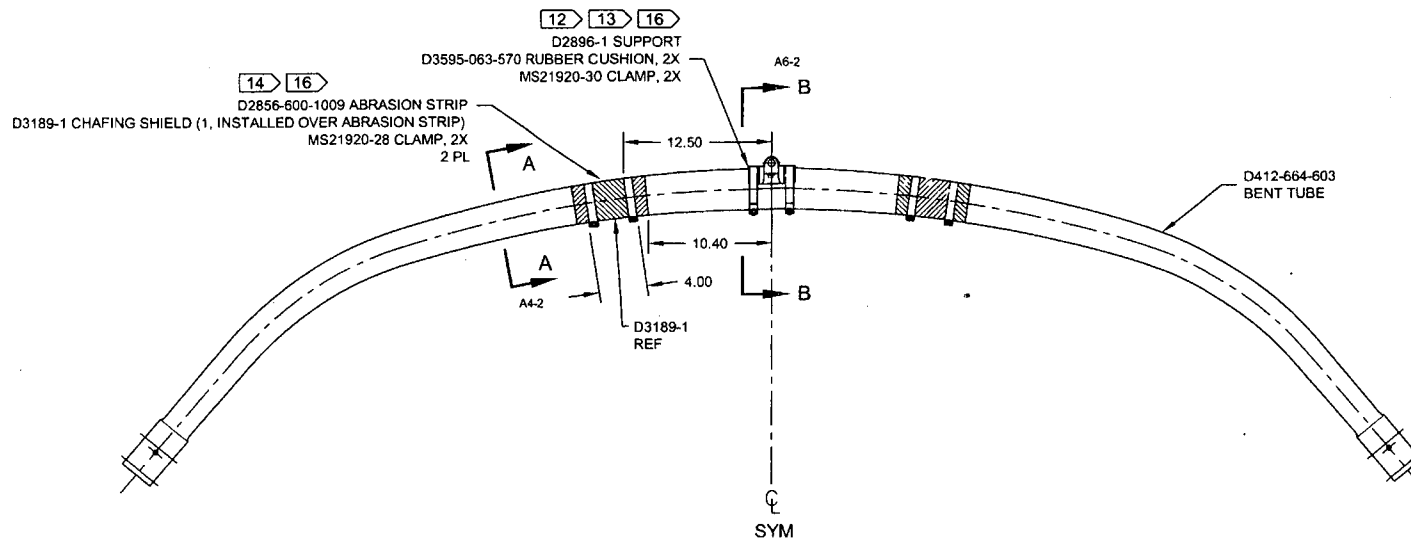
GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6009-129
FINISHED LENGTH = 124.100±0.020 (BEFORE BENDING/TRIMMING)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D412-664-243" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 47.0 lbs (PER IIN-D212-664)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2896-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-30 CLAMPS (OR -32) WITH D3595-063-570 RUBBER CUSHIONS TO SECURE THE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.
- 14) INSTALL D2856-600-1009 ABRASION STRIPS WITH A 0.13 REF GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
- 15) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 16) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

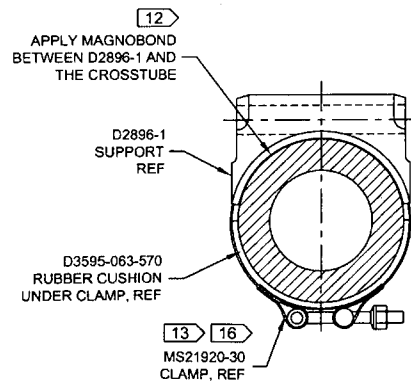
② DEO ATTACHED
RELEASED
R 2009-10-29
WJP

E	REFORMAT/REVISE GENERAL NOTES; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A6-3); ADD TOLERANCE (ZN B6-3, C4-3, C8-3 & C5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	09.09.30
D	REMOVE D2732-058, CHANGE TO D3595-063-570	PH	07.03.09
C	REMOVE D2856-600-1087, ADD D2732-058 & MAGNOBOND 6398, MS21920-32 WAS MS21920-30	MB	06.10.27
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	PH	01.10.17
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	REV. E	
CHECKED	PH	DRAWING NO.	SHEET 1 OF 4
MFG. APPR.	PH	D412-664-243	
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	CROSSTUBE ASSEMBLY (412 HI AFT)	NTS
DATE	09.09.30	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

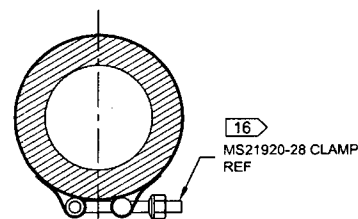
PROLIFER



D212-664-243
ASSEMBLY DETAIL



SECTION B-B D4-2
SCALE 4X



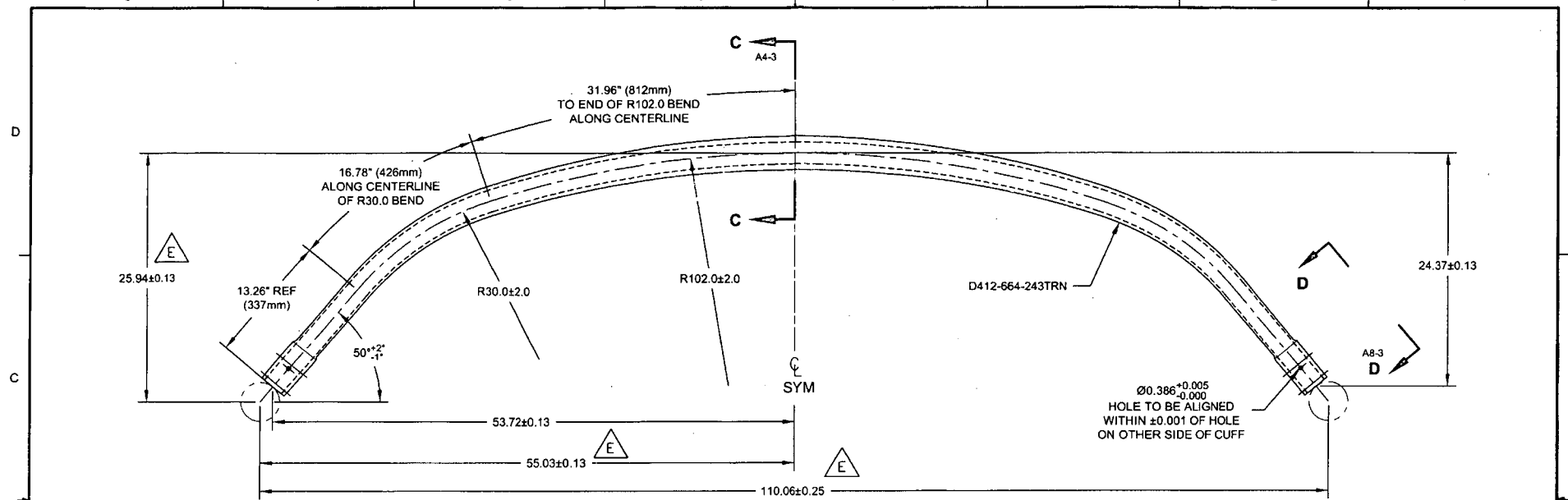
SECTION A-A C6-2
SCALE 4X

2 DEO ATTACHED

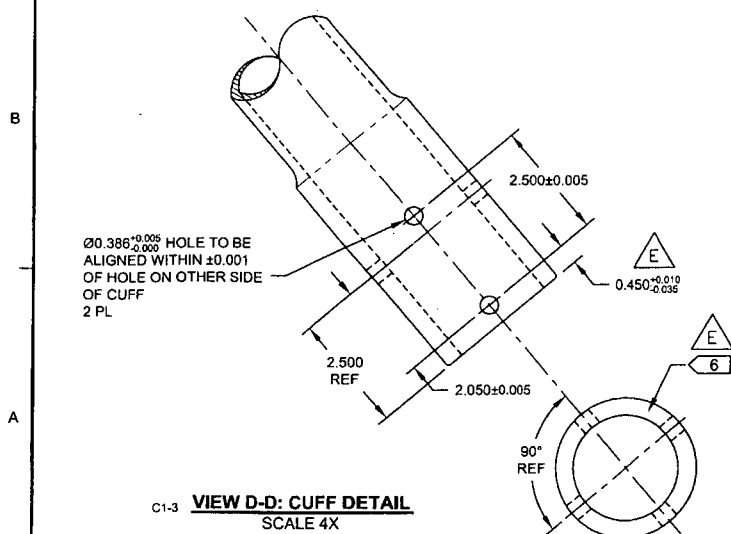
RELEASED
2009-10-28
WJ

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Q	DRAWING NO.	REV. E
MFG. APPR.	DS	D412-664-243	SHEET 2 OF 4
APPROVED	AP	TITLE	SCALE
DE APPR.	W	CROSSTUBE ASSEMBLY (412 HI AFT)	NTS
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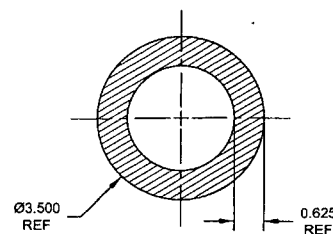
8 7 6 5 4 3 2 1



D412-664-603 10
BENDING AND DRILLING DETAIL E



C1-3 **VIEW D-D: CUFF DETAIL**
 SCALE 4X



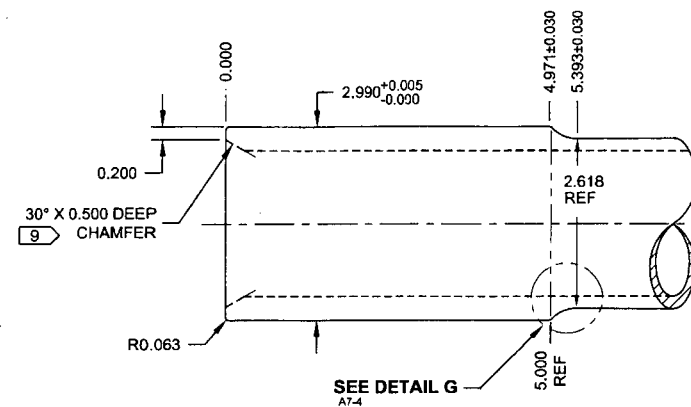
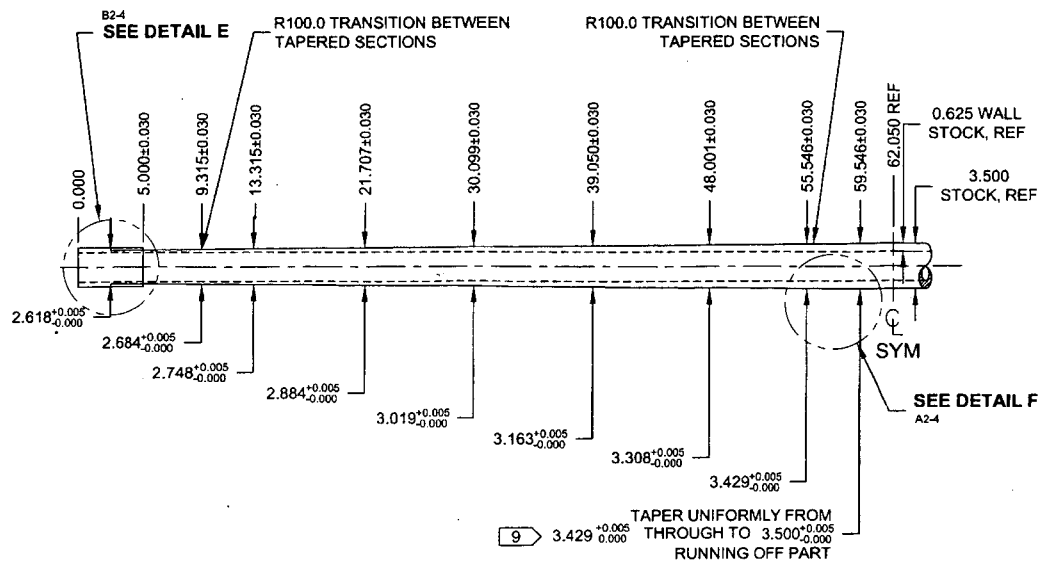
SECTION C-C D5-3
 SCALE 4X

② DEO ATTACHED

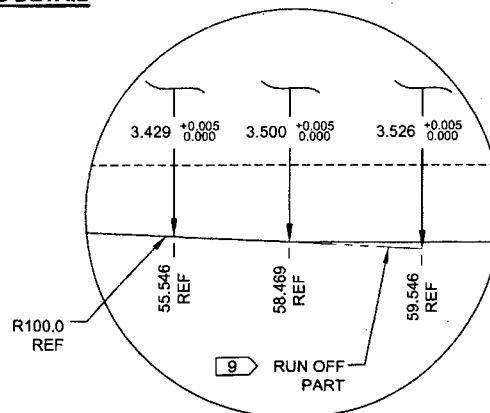
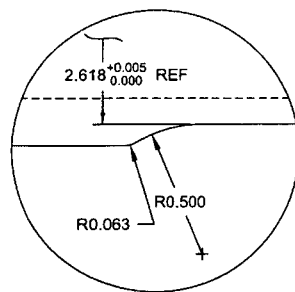
RELEASED
 2009-10-29
 MP

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. E
MFG. APPR.	DS	D412-664-243	SHEET 3 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	TH	CROSSTUBE ASSEMBLY (412 HI AFT)	NTS
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8 7 6 5 4 3 2 1



D412-664-243TRN **TURNING DETAIL**



2 DEO ATTACHED

RELEASED
2009-10-29

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	97	DRAWING NO.	REV. E
MFG. APPR.	DS	D412-664-243	SHEET 4 OF 4
APPROVED	AP	TITLE	SCALE
DE APPR.	TH	CROSSTUBE ASSEMBLY (412 HI AFT)	NTS
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DRAWING NO. D412-664-243	TITLE CROSSTUBE ASSEMBLY (412 HI AFT)	REV. E	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D412-664-243-E-1	SHEET NO. SHEET 1 OF 2	SCALE NTS
DRAWN	CHECKED	MFG. APPR.	APPROVED	DE APPR.			
DATE 11.03.31	DATE 11/03.31	DATE 11.03.31	DATE 11/03.31	DATE 11-03.31			

PURPOSE:

REMOVED ABRASION STRIP IN FAVOR OF A THIN LAYER OF PROSEAL 890.

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

IS:

Item	Qty -243	Part Number	Description
6	0	D2856-600-1009	ABRASION STRIP

WAS:

6	2	D2856-600-1009	ABRASION STRIP
---	---	----------------	----------------

NOTES 2 AND 14, SHEET 1 ARE AMENDED AS FOLLOWS:

IS:

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
MASK UNDERSIDE OF CROSSTUBE AS SHOWN (HATCHED AREA)
PAINT OUTSIDE PER DART QSI 005 4.2
AFTER PAINTING, APPLY CLEAR COAT ON HATCHED AREA
- 14) APPLY A THIN COAT OF PROSEAL 890 ON INSIDE CONCAVE SURFACE OF D3189-1
CHAFING SHIELD AND LET CURE PER MANUFACTURER'S INSTRUCTIONS. INSTALL
PROSEALED D3189-1 CHAFING SHIELD ONTO CROSSTUBE BY APPLYING A THIN COAT OF
PROSEAL 890 ONTO CROSSTUBE. BE SURE TO ELIMINATE ANY AIR GAPS.

WAS:

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 14) INSTALL D2856-600-1009 ABRASION STRIPS WITH A 0.13 REF GAP ON BOTTOM SIDE OF
CROSSTUBE PER QSI 035.

RELEASED
2011-04-07
WDE

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DRAWING NO. D412-664-243	TITLE CROSSTUBE ASSEMBLY (412 HI AFT)	REV. E	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D412-664-243-E-1	SHEET NO. SHEET 2 OF 2	SCALE NTS
DRAWN <i>[Signature]</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 11.03.31	DATE 11.03.31	DATE 11.03.31	DATE 11.03.31	DATE 11.03.31		

IS:

D3189-1 CHAFING SHIELD (1, INSTALLED OVER PROSEAL 890)
MS21920-28 CLAMP, 2X
2 PL

D412-664-603
BENT TUBE

2.00
1.00

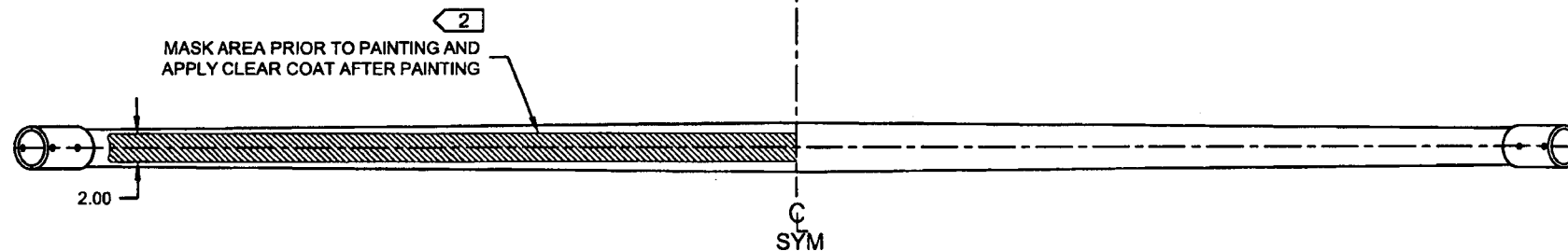
WAS:

D2856-600-1009 ABRASION STRIP
D3189-1 CHAFING SHIELD (1, INSTALLED OVER ABRASION STRIP)
MS21920-28 CLAMP, 2X
2 PL

D3189-1
REF

**D412-664-243
ASSEMBLY DETAIL**

RELEASED
2011-04-07
[Signature]



DRAWING NO. D412-664-243	TITLE CROSSTUBE ASS'Y (412 HI AFT)	REV. E	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D412-664-243-E-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN 92	CHECKED SS	MFG. APPR. E	APPROVED MP		DE APPR. H		
DATE 11.09.07	DATE 11.09.19	DATE 11.09.19	DATE 11.09.19		DATE 11.09.19		

PURPOSE:

REPLACE MAGNOBOND WITH 3M DP460 SCOTCH-WELD EPOXY ADHESIVE

CHANGE:

IS:

Item	Qty -243	Part Number	Description
9	A/R	SCOTCH-WELD DP460	EPOXY ADHESIVE, 3M SCOTCH-WELD

WAS:

9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
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NOTE 12 & 16, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) INSTALL D2896-1 CENTER SUPPORT USING A 0.04" TO 0.07" THICK LAYER OF SCOTCH-WELD DP460 PER QSI 015. LET CURE FOR 24 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 16) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER ADHESIVE HAS CURED FOR 24 HOURS.**

WAS:

- 12) INSTALL D2896-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 16) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
2011-09-29
MP



DART AEROSPACE

1270 Aberdeen Street
Hawkesbury, Ontario K6A 1K7

RETURN AUTHORIZATION

Duplicate
(FILE)

Date: 20-Mar-12
Customer Name: Eagle Copters Maintenance
Customer Code: EAG002
Telephone No: 403-250-7370
E-mail Address: mmiele@eaglecopters.com
Contact Name: Mark Miele
Issued by: Sian Willems

DART RA Number: RA111340
DHS RA Number: n/a
DHS PO #: n/a
DART Invoice #: INV7705 (accpac)
Customer Ref: PO08-003204
PAR/CAR/NCR/SQ: CSR12-91

Quantity	Part Number	Description	Batch Number
1	D412-664-203	Crosstube Aft	B42429

Reason for Return: See attached

Credit Instructions:

☐ Full credit
☒ None

Return Instructions: Commercial Invoice Yes ☐
Documentation (STC/ARC/ICA) Yes ☐
Packing Slip Yes ☐

Include on Commercial Invoice:
Part Number/Description / Value in USD
Parts are aircraft parts / return to Manufacturer

Shipping Instructions: Prepaid ☒ Collect ☐ Courier ☐
Account #

RECEIVING RETURN AUTHORIZATION

Receiver: <i>J. Miele</i>	Condition of Packaging: <i>Good</i>	Paperwork: RA	P/L NONE	Photograph Required Yes No
Date: <i>12/5/15</i>	Freight Company: <i>Day Ross</i>	CHG #	W/O#	Disposition
Quantity	Part Number	Batch	QC Verification	
1 x	D412-664-203	B42429		

QC Inspector: *S* Photograph Attached ☒ Condition: Sealed Complete Short H/W Short Kit No P/W Damaged
Date: *12/5/15* Yes No

QC Comments:

Pls read Attach instr. sheet

Special Return/Rework Instructions:

No re-stocking fee

Issue Credit: Yes ☒ NoGM Approval: Date:

Invoice Amount:
Restocking Fee:
Freight:
Net Credit:

Quality Assurance:

Close Date:

RA 111340 D412-664-203

B42429

Received @ Dart May 15th, 2012
Inspected @ Dart May 29th, 2012

Customer: Eagle Copters Maintenance
Customer Contact: Mark Miele
Shipped from: Calgary AB, CANADA

Instructions for RA 111340 D412-664-203 B42429 CHG006

- Tube has marks on cuffs from being installed
- Was repainted
- Marks on one Chamfering shield
- No KIT RETURNED
- Need conformation that tube was never flown
- Tube needs to be striped and re-primed and painted as per current Drawing
- Needs New Work Order for work
- Needs new Paper Work and Labels
- Needs New Kit also

Time Estimate = 6 HOURS

Departments required: 5h Stripping, painting, assembling 1h Stores

Pictures Attached = YES

MS240426 - 6
ANG 105066 - 18
ANG-404 - 4
ANG-411A - 2

**THIS INSTRUCTION SHEET MUST
BE ATTACHED TO THE
RESTOCKING WORK ORDER AT
ALL TIMES!!!!**

Eric Downing

From: David Shepherd <dshepherd@dartaero.com>
Sent: Thursday, June 14, 2012 12:11 PM
To: 'Eric Downing'
Cc: psmith@dartaero.com; 'Marc Bellavance'; 'Bill Beckett'; 'Sian Willems'; 'L Lacelle'; 'Melanie Fauteux'; 'Cathy Kerr'
Subject: RE: RA111340

Bill,

You and I had a telecon about this tube. It was manufactured quite some time ago and had pronounced rippling in the bends. It had been installed on an aircraft and not flown, but the rocker beam had caused some denting of the chafing shields. It also did not have an inspection window. Therefore, based on the ongoing level of scrutiny that these parts are receiving, the decision was to have the crosstube returned to Dart and scrapped so that it could no longer be installed on a serviceable aircraft.

I am of the opinion that this tube should still be scrapped. Please confirm that you still agree with this decision.

David

From: Eric Downing [<mailto:edowning@dartaero.com>]
Sent: June-14-12 9:46 AM
To: David Shepherd
Cc: psmith@dartaero.com; 'Marc Bellavance'; 'Bill Beckett'; Sian Willems; 'L Lacelle'; Melanie Fauteux; Cathy Kerr
Subject: RE: RA111340

Hey David this is about the cross tube returned from Eagle with ripples in the bends.

You said this should be scraped. Yes

Thanks

Eric Downing

From: Eric Downing [<mailto:edowning@dartaero.com>]
Sent: Wednesday, June 13, 2012 2:07 PM
To: Sian Willems; 'L Lacelle'; Melanie Fauteux; Cathy Kerr
Cc: psmith@dartaero.com; 'Marc Bellavance'; 'Bill Beckett'
Subject: RA111340

Sian can you contact Eagle Copters (Mark Miele) and find out if this cross tube was flown.

Here is the instructions for this return if it was not flown. If it was it will have to change work instructions. Please read the attachment and see the pictures.

Thanks

Eric Downing